

Work Order ID 101881

\*101881\*

Page 1

Item ID: D350-636-014

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Skidtube RH

Start Date: 5/17/13 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 5/31/13 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan: MLS

Date: 13-05-17 Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2750

F

D3492

C

100

0.00

\*1000\*

DOCUMENT CONTROL

DC

Memo

17.10.

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-014 CHG 006

B101881RH

# Work Order ID 101881

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**\*101881\***

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Item ID: D350-636-014

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH

Start Date: 5/17/13 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 5/31/13 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***  
Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00

**\*110\***

Skidtubes

Skidtubes

Memo

0.00

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside  
AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500",  
deburr.

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade  
fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-4 details). Drill using drill  
Jig DT8150 & DT8864A for first side only DT8864B for second side (detail B)

7- Clecko DT8864B on second side of tube and drill pilot holes for detail B.  
\*\*\*SECOND SIDE\*\*\*

8- Open up holes for SECTION BE-BE to 0.375" (2 holes per side) and blade  
fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750.  
Open holes for ground handling and detail AB to 0.500" (8 holes per side)

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to  
0.297".

10-Open up holes of Detail A-A to 0.297" (total of 2 holes per side)

*BE 13/03/28*

*BE 13/05/30*

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Item ID: D350-636-014

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\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Skidtube RH

Start Date: 5/17/13 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 5/31/13 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left  
from bending as per QSI 004

A/R Aluminum Rod batch: M125/27 BE 13/03/28

12-Grind welds flush as per Dwg D2750

BE 13/03/28

120

\*120\*

QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

SWD 13 5 30 (DAS) 09

130

\*130\*

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

SWP 13 5 30

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**Accept**

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

**Cust Item ID:**

**\* 1 \***

**\* 1 \***

**Customer:**

**Reference:**

### Process Plan:

Date:

**Tooling:**

Date:

Run Start \*NR1\*

**QC:**

Date:

**SPC (Y/N):**

Date:

Stop \*NR2\*

### Operation Description

### Set Up/ Run Hours

**Tool ID**

Tool #

**Plan  
Code**

**Accept  
Qty**

Reject  
QtyReject  
Number

**Insp.  
Stamp**

140

Chemical Conversion Coat per QSI005 4.1

0.00

**\*140\***

HandFinish

## Hand Finishing

## Memo

0.00

150

QC7-Inspect Chemical Conversion Coat

0.00

**\*150\***

QC

## Quality Control

## Memo

0.00

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Item ID: D350-636-014

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH

Start Date: 5/17/13 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 5/31/13 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

0.00

**\*160\***

Skidtubes

Skidtubes

Memo

0.00

1-Open up holes section BE-BE 0.500" (4 per side) as per dwg D2750

2-Open holes section BC-BC 0.3125" (4 per side)

3-Open up holes of Detail AB and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

4-Chamfer holes of section BE-BE, BC-BC, AB and ground handling (welding instructions on sheet 11)

5-Deburr and blow out all chips from inside of tube. Prepare tube for welding, remove alodine as required.

6-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch:

120 473

exp. date:

13/06/22

7- Weld spacers D3490-1, D3490-5 and D2743 as per dwg D2750 &amp; QSI004 (welding instructions on sheet 11)

A/R Aluminum Rod

batch:

M125127

8-Grind welds flush as per Dwg D2750

9-Spot face ground handling holes (total of 4 places per side) as per dwg D2750

10-Deburr holes

13/06/03

BE 13/06/04

J. W. B. 13/06/05

&gt; BE 13/06/05

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Item ID: D350-636-014

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Skidtube RH

Start Date: 5/17/13 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 5/31/13 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* QC Quality Control	QC10- Inspect visual per QSI004- ground welds  Memo	0.00 0.00				1			
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo ***VERIFY C'BOARD IS GOOD***	0.00 0.00				1			
190 *190* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3  Memo Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.	0.00 0.00							

IX of m-f 13/06/05

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Item ID: D350-636-014

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\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Skidtube RH

Start Date: 5/17/13 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 5/31/13 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

\*200\*

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

3200F

0.00

0.00

QC3- Inspect Part Finish

Memo

Inspect for foreign object per QSI 024

210

\*210\*

QC

Quality Control

1X4 m 13/06/06

13H c 13/06/07

M125620

7:40  
8:10

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Item ID: D350-636-014

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube RH

Stop **\*NS2\***

Start Date: 5/17/13 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 5/31/13 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	HandFinishing	0.00							
<b>*230*</b>	Memo	0.00							
Hand Finish	1-Install inserts as per dwg D2750								
Hand Finishing	2-assemble o'ring as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: <u>M1121651</u>								
	3-Assemble tube hardware as per dwg D2750 sika flex batch: <u>M1125473</u>								
	4-Inspect For Foreign Objects								
	5-Spray inside of tube with "LPS-3" batch: <u>N14</u>								
	6-Install blade fitting D3488-041, wearshoe SIKA FLEX 241 BATCH: <u>M1125473</u> EXP DATE: <u>13106</u>								
	7-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: <u>M1121651</u>								
	8-Coat all exposed fasteners with "LPS Procyon" batch: <u>M1127906</u>								

1R11 4 M 13/06/07



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Item ID: D350-636-014

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\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Skidtube RH

Stop \*NS2\*

Start Date: 5/17/13 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 5/31/13 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	QC5- Inspect part completeness to step on W/O	0.00				1			
*240*									
QC	Memo	0.00							
Quality Control									
250	Pick Kit	0.00							
*250*									
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
*260*									
QC	Memo	0.00							
Quality Control									

7.10.13-06-12

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Item ID: D350-636-014

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Skidtube RH

Stop \*NS2\*

Start Date: 5/17/13 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 5/31/13 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270		0.00							
*270*	Packaging	0.00							
Packaging	Memo								
Packaging	Package as per PPP D350-636-014								
280		0.00							
*280*	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo								
Quality Control									

13-06-21

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Work Order ID: 101881

\*101881\*

Parent Item: D350-636-014

\*D350-636-014\*

Parent Item Name: Skidtube RH

Start Date: 5/17/13

Required Date: 5/31/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:H02.09.25Rearranged procedure stepsKJ  
 IPP Rev:I05.12.08Rearranged procedure stepsEC  
 IPP Rev:J06.03.30Per rev. D EC  
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC  
 IPP Rev:M 08-09-23 revF as per dwg DD verified by:ec IPP Rev:N  
 10.06.22 revise seq110 DD verf:EC IPP Rev:O 10.10.01 as  
 per IIN revH DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-3-BENT		Manufactured	No			110	Each	35.0000	1	1			

\*D2600-3-BENT\*

\*\*

BE 13/05/28

Extrusion Bent

## Location

## Loc Qty

## Loc Code

LG

35

100688

4

101188

14

66875

7

73253

1

75021

1

75022

1

75023

1

81330

4

83305

1

97615

1

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Work Order ID: 101881

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

\*101881\*

\*D350-636-014\*

Start Date: 5/17/13

Required Date: 5/31/13

Start Qty: 1.00

Required Qty: 1.00

D2739

Manufactured No

160

Each

22.0000

1

1

\*D2739\*

3501 Beam

\*\*

1

13/06/03

## Location

## Loc Qty

## Loc Code

LG

22

101113

5

101133

2

101441

4

101851

4

72155

1

81508

1

85487

1

87734

1

97319

1

97618

2

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Work Order ID: 101881

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

\*101881\*

\*D350-636-014\*

Start Date: 5/17/13

Required Date: 5/31/13

Start Qty: 1.00

Required Qty: 1.00

D2743

Manufactured No

160

Each

167.0000

8

8

\*D2743\*

Crossbolt Spacer

\*\*

BE13/04/04

## Location

## Loc Qty

## Loc Code

LG

97584

1

LG001

131

67766

4

68251

3

73403

64

74445

1

79517

2

99032

5

99785

52

LG002

35

81965

23

83262

2

85459

4

88504

2

95148

2

95901

2

8

D2744

Manufactured No

160

Each

95.0000

1

1

\*D2744\*

Cap

\*\*

BB13/05/28

## Location

## Loc Qty

## Loc Code

LG

97543

94

LG002

1

62715

1

1

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Work Order ID: 101881

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

\*101881\*

\*D350-636-014\*

Start Date: 5/17/13

Required Date: 5/31/13

Start Qty: 1.00

Required Qty: 1.00

D3490-1

Manufactured No

160

Each

48.0000

4

4

\*D3490-1\*

Cross Bolt Spacer

\*\*

BE 13/06/04

## Location

## Loc Qty

## Loc Code

LG001

44

100560

30

62450

2

74875

4

77042

3

95977

1

97621

2

99074

2

LG004

4

81976

2

94805

2

D3490-5

Manufactured No

160

Each

10.0000

4

4

\*D3490-5\*

Cross Bolt Spacer

\*\*

BE 13/06/04

B 10/06/07

## Location

## Loc Qty

## Loc Code

LG

7

97269

7

LG001

2

83373

2

LG004

1

87669

1

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Parent Item: D350-636-014

Parent Item Name: Skidtube RH

\*101881\*

\*D350-636-014\*

Start Date: 5/17/13

Required Date: 5/31/13

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased

No

230

Each

898.0000

38

38

\*AI S4-1032-225\*

Insert

AL S4-1032-225

\*\*

13/06/07

## Location

## Loc Qty

## Loc Code

FP001

842

118386

55

118966

68

120410

10

120451

13

121269

77

122827

619

ST280

56

x38

118520

56

AN3C5A

Purchased

No

230

Each

2,423.000

34

34

\*AN3C5A\*

Bolt

\*\*

13/06/07

## Location

## Loc Qty

## Loc Code

FG

5

122800

5

ST350

28

116419

28

ST512

2390

124221

732

125388

1658

y34

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Parent Item: D350-636-014

Parent Item Name: Skidtube RH

\*101881\*

\*D350-636-014\*

Start Date: 5/17/13

Required Date: 5/31/13

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

226.0000

4

4

**\*AN3C6A\***

BOLT

\*\*

13/06/07

Location

Loc Qty

Loc Code

FG

10

122416

10

FP001

30

122599

30

FP002

1

111982

1

ST351

185

122416

185

✓

AN6C44A

Purchased

No

230

Each

158.0000

4

4

**\*AN6C44A\***

BOLT

\*\*

13/06/07

Location

Loc Qty

Loc Code

FG

2

103964

2

st503

156

125389

156

✓

AN8C35A

Purchased

No

230

Each

39.0000

1

1

**\*AN8C35A\***

BOLT

\*\*

13/06/07

Location

Loc Qty

Loc Code

FG

5

121275

5

FP001

2

115960

1

121275

1

st507

32

124827

32

✓

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Shop Packet Print

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Parent Item: D350-636-014

Parent Item Name: Skidtube RH

\*101881\*

\*D350-636-014\*

Start Date: 5/17/13

Required Date: 5/31/13

Start Qty: 1.00

Required Qty: 1.00

AN960C10L

NAS1149C0332

Purchased

No

230

Each

0.0000

38

38

\*AN960C10I \* y

washer

D2745

Manufactured

No

230

Each

130.0000

8

8

\*D2745\*

Bushing

\*\*

(x38) ul 13/06/07

\*\*

ul 13/06/07

## Location

## Loc Qty

## Loc Code

FP001

10

B100991

x<sup>0</sup>

69529

1

76142

1

79518

6

83260

2

FP-001

1

92539

1

ST017

119

100456

24

94715

36

95878

3

97574

56

D3488-042

Manufactured

No

230

Each

26.0000

1

1

\*D3488-042\*

Blade Fitting Assembly, RH

\*\*

ul 13/06/07

## Location

## Loc Qty

## Loc Code

FP001

14

83417

1

94963

1

97026

1

98887

11

FP002

12

97672

12

X1

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Shop Packet Print

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Parent Item: D350-636-014

Parent Item Name: Skidtube RH

\*101881\*

\*D350-636-014\*

Start Date: 5/17/13

Required Date: 5/31/13

Start Qty: 1.00

Required Qty: 1.00

D3492-1

Manufactured No

230

Each

166.0000

8

8

\*D3492-1\*

Plug

\*\*

u 13/06/07

## Location

## Loc Qty

## Loc Code

FP001

166

100504

57

101063

80

69531

8

74444

2

76235

4

83098

7

88541

3

91466

2

97266

3

x 8

D3492-5

Manufactured No

230

Each

126.0000

8

8

\*D3492-5\*

Plug

\*\*

u 13/06/07

## Location

## Loc Qty

## Loc Code

FP001

86

87146

1

88214

81

93891

4

FP002

40

94508

40

x 8

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Parent Item: D350-636-014

Parent Item Name: Skidtube RH

\*101881\*

\*D350-636-014\*

Start Date: 5/17/13

Required Date: 5/31/13

Start Qty: 1.00

Required Qty: 1.00

D3535-25

Manufactured No

230

Each

28.0000

1

1

\*\*

\*D3535-25\*

Wearshoe

13/06/07

Location

Loc Qty

Loc Code

FG

2

95077

2

FP001

11

98969

11

FP002

15

100391

5

62233

1

81357

1

87385

1

90061

1

98378

6

X1

D3536-25

Manufactured No

230

Each

13.0000

1

1

\*\*

\*D3536-25\*

Gasket

13/06/07

Location

Loc Qty

Loc Code

FG

6

87053

2

95328

4

FP001

7

100719

3

83900

1

89057

1

93696

1

95686

1

B101462

X1

# Picklist Print

May-17-13 1:52:58 PM

Page 10

Work Order ID: 101881

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

\*101881\*

\*D350-636-014\*

Start Date: 5/17/13

Required Date: 5/31/13

Start Qty: 1.00

Required Qty: 1.00

D3537-1

Manufactured No

230

Each

104.0000

3

3

\*D3537-1\*

Wearpad

\*\*

11

13/06/07

## Location

## Loc Qty

## Loc Code

FG

20

79833

10

88562

10

FP001

84

83254

1

83255

3

87697

1

88562

9

91668

24

94395

1

97289

1

99061

44

B99825

X3

D3631-1

Manufactured No

230

Each

305.0000

8

8

\*D3631-1\*

Washer

\*\*

11

13/06/07

## Location

## Loc Qty

## Loc Code

FP001

290

100446

68

100969

200

81874

2

83588

18

91606

1

94702

1

FP002

15

68062

2

75548

13

X4

X4

# Picklist Print

May-17-13 1:52:58 PM

Page 11

Work Order ID: 101881

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

\*101881\*

\*D350-636-014\*

Start Date: 5/17/13

Required Date: 5/31/13

Start Qty: 1.00

Required Qty: 1.00

D3791-1

Manufactured No

230

Each

12.0000

1

1

\*D3791-1\*

Wearplate

\*\*

13/06/07

## Location

## Loc Qty

## Loc Code

FP002

12

62239

2

83392

1

99712

9

D3793-1

Manufactured No

230

Each

20.0000

1

1

\*D3793-1\*

Wearshoe

\*\*

13/06/07

## Location

## Loc Qty

## Loc Code

FP002

20

100333

14

82171

2

87273

3

92382

1

D3793-3

Manufactured No

230

Each

29.0000

1

1

\*D3793-3\*

Wearshoe

\*\*

13/06/07

## Location

## Loc Qty

## Loc Code

FP001

1

92487

1

FP002

28

100296

12

98289

8

99604

8

# Picklist Print

May-17-13 1:52:58 PM

Page 12

Work Order ID: 101881

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

\*101881\*

\*D350-636-014\*

Start Date: 5/17/13

Required Date: 5/31/13

Start Qty: 1.00

Required Qty: 1.00

D3794-1

Manufactured No

230

Each

15.0000

1

1

\*D3794-1\*

Gasket

\*\*

13/06/07

## Location

## Loc Qty

## Loc Code

FP001

15

100498

10

87631

2

92426

1

95913

1

99375

1

X1

D3794-3

Manufactured No

230

Each

22.0000

1

1

\*D3794-3\*

Gasket

\*\*

13/06/07

## Location

## Loc Qty

## Loc Code

FP001

22

100326

16

74530

2

92658

1

99305

3

X1

MS21043-6

Purchased No

230

Each

296.0000

4

4

\*MS21043-6\*

NUT

\*\*

12/06/07

## Location

## Loc Qty

## Loc Code

FG

20

103693

20

ST315

116

117887

2

120308

2

124231

112

ST506

160

124485

160

X-1

# Picklist Print

May-17-13 1:52:58 PM

Page 13

Work Order ID: 101881

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

\*101881\*

\*D350-636-014\*

Start Date: 5/17/13

Required Date: 5/31/13

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

230

Each

72.0000

1

1

**\*MS21083C8\***

NUT

\*\*

u 13/06/07

Location

Loc Qty

Loc Code

ST319

69

123900

3

125484

66

ST506

3

124308

3

NAS1149C0832R

Purchased

No

230

Each

152.0000

1

1

**\*NAS1149C0832R\***

WASHER

\*\*

u 13/06/07

Location

Loc Qty

Loc Code

ST292

152

122441

152

NAS1515H3L

Purchased

No

230

Each

457.0000

4

4

**\*NAS1515H3L \***

WASHER

\*\*

u 13/06/07

Location

Loc Qty

Loc Code

FG

40

102472

40

ST297

417

121556

45

124542

372

XJ

# Picklist Print

May-17-13 1:52:59 PM

Page 14

Work Order ID: 101881

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

\*101881\*

\*D350-636-014\*

Start Date: 5/17/13

Required Date: 5/31/13

Start Qty: 1.00

Required Qty: 1.00

NAS1611-005

Purchased

No

230

Each

204.0000

8

8

**\*NAS1611-005\***

O-RING

\*\*

13/06/07

## Location

## Loc Qty

## Loc Code

FP001

154

106099

18

114220

14

122441

15

122538

7

125654

100

FP002

50

123900

50

NAS1611-010

Purchased

No

230

Each

509.0000

8

8

**\*NAS1611-010\***

O-RING

\*\*

13/06/07

## Location

## Loc Qty

## Loc Code

FP001

509

110915

14

117460

8

118077

1

118612

3

119438

7

121259

2

121584

2

121723

7

122151

8

123348

29

123352

4

124580

4

125484

420

13/06/07



# Picklist Print

May-17-13 1:52:59 PM

Page 15

Work Order ID: 101881

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

\*101881\*

\*D350-636-014\*

Start Date: 5/17/13

Required Date: 5/31/13

Start Qty: 1.00

Required Qty: 1.00

AN8C21A

Purchased

No

250

Each

68.0000

\*AN8C21A\*  
BOLT

SM

## Location

## Loc Qty

## Loc Code

ST

2

123966

2

ST342

66

123642

1

123966

2

124884

41

125486

22

\*\* 2

M.H. 13-06-12

AK

D2741

Manufactured

No

250

Each

29.0000

\*D2741\*  
Blade, 350 Skidtube

SM

## Location

## Loc Qty

## Loc Code

FG

6

85480

1

98323

5

ST466

23

71856

1

85480

1

98323

21

\*\* 0 2X 1

M.H.

AK

D3493-1

Manufactured

No

250

Each

38.0000

\*D3493-1\*  
Washer

SM

## Location

## Loc Qty

## Loc Code

FG

10

97201

10

ST052

28

99009

28

\*\* 2 1X 2

M.H.

AK

\*\*\*ONLY INSTALL IF INSTALLING ON APICAL  
FLOAT SYSTEM\*\*\*

May-17-13 1:52:59 PM

Shop Packet Print

Page 15

# Picklist Print

May-17-13 1:52:59 PM

Page 16

Work Order ID: 101881

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

\*101881\*

\*D350-636-014\*

Start Date: 5/17/13

Required Date: 5/31/13

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

72.0000

\*\* 2 2

\*MS21083C8\*

NOT

Smf

## Location

ST319

123900

125484

ST506

124308

## Loc Qty

69

3

66

3

3

## Loc Code

2x

M.D. 13-06-12

AA SL

NAS1149D0863J

Purchased

No

250

Each

1,230.000

\*\* 2 2

\*NAS1149D0863J\*

WASHER

Smf

## Location

FP001

118078

ST294

123900

st510

125268

125484

125635

## Loc Qty

14

14

16

16

1200

600

300

300

## Loc Code

2x

M.D.

AA SL

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

# **GENERAL NOTES:**

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

F	INCORPORATE DSI 9413: QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PA	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
DRAWN	RAH		
CHECKED	AS	DRAWING NO.	REV. F
MFG. APPR.	AS	D2750	SHEET 1 OF 11
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION FROM DART AEROSPACE USA, INC.	

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DATE: 08-07-16

FILE

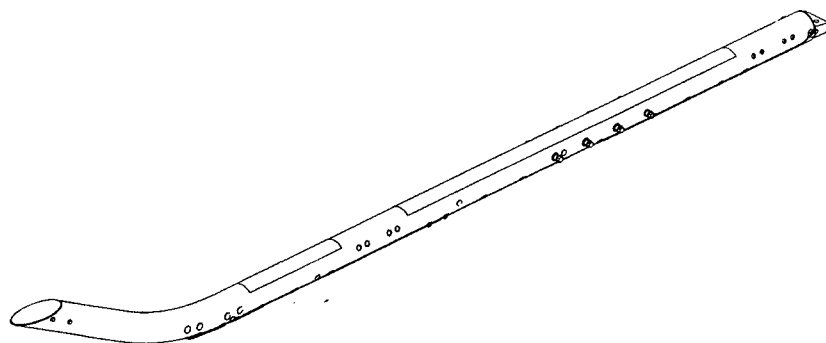
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101881-MCS

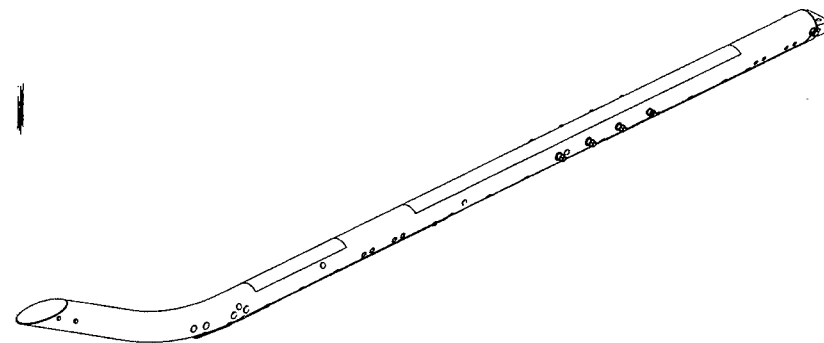
13-05-17

RELEASED

101881



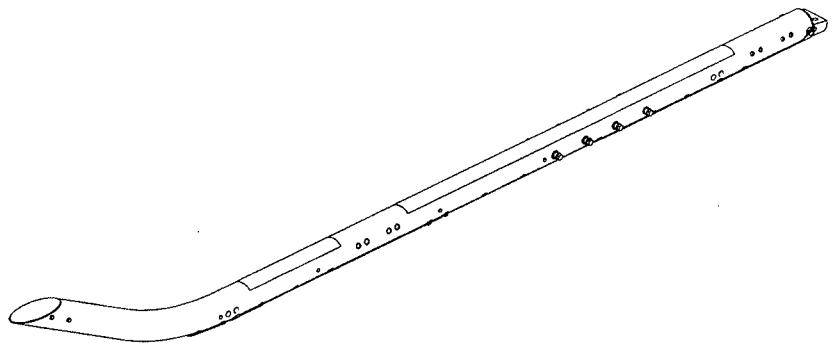
D2750-041 350 SKIDTUBE ASSEMBLY, LH



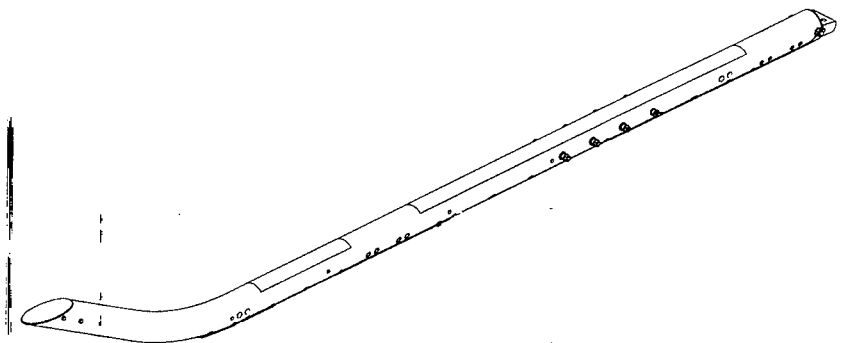
D2750-042 350 SKIDTUBE ASSEMBLY, RH

**RELEASED**  
18 OCT 1978

DESIGN	PC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. F
MFG. APPR.	NY	D2750	SHEET 2 OF 11
APPROVED	NY	TITLE	SCALE
DE APPR.	NY	350 SKIDTUBE ASSEMBLY	NTS
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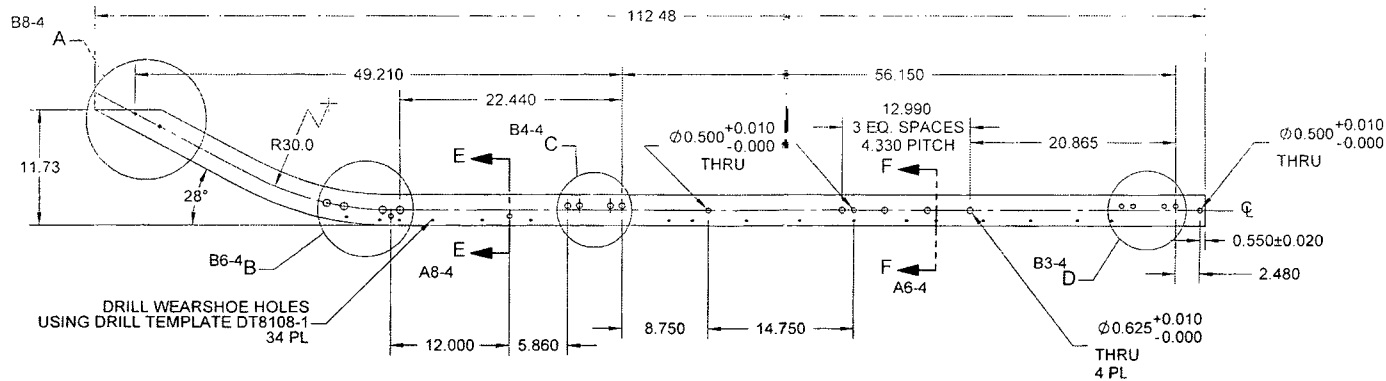
D2750-043 350 SKIDTUBE ASSEMBLY, LH



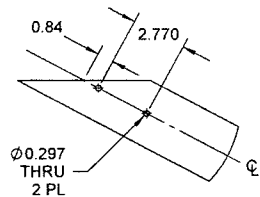
D2750-044 350 SKIDTUBE ASSEMBLY, RH

RELEASED  
68-9-22/100

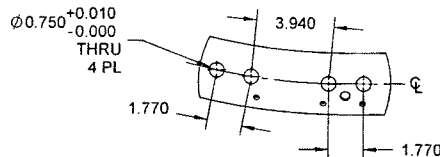
DESIGN	PD	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	PD	PORT HADLOCK, WA	
CHECKED	MA	DRAWING NO.	REV. F
MFG. APPR.	MA	D2750	SHEET 3 OF 11
APPROVED	MA	TITLE	SCALE
DE APPR.	MA	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



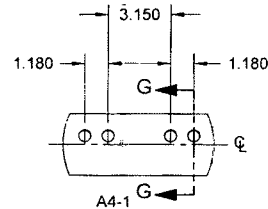
**D2750-1 LH SKIDTUBE**



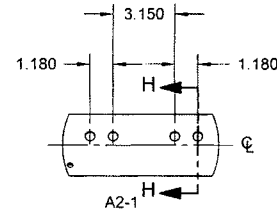
**DETAIL A**  
SCALE 2X



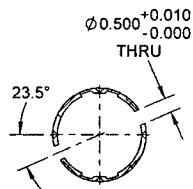
**DETAIL B**  
SCALE 2X



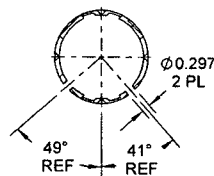
**DETAIL C**  
SCALE 2X



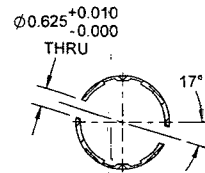
**DETAIL D**  
SCALE 2X



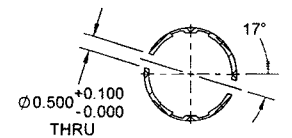
**SECTION E-E**  
SCALE 3X, 2 PL



**SECTION F-F**  
SCALE 3X, 17 PL



**SECTION G-G**  
SCALE 3X, 4 PL

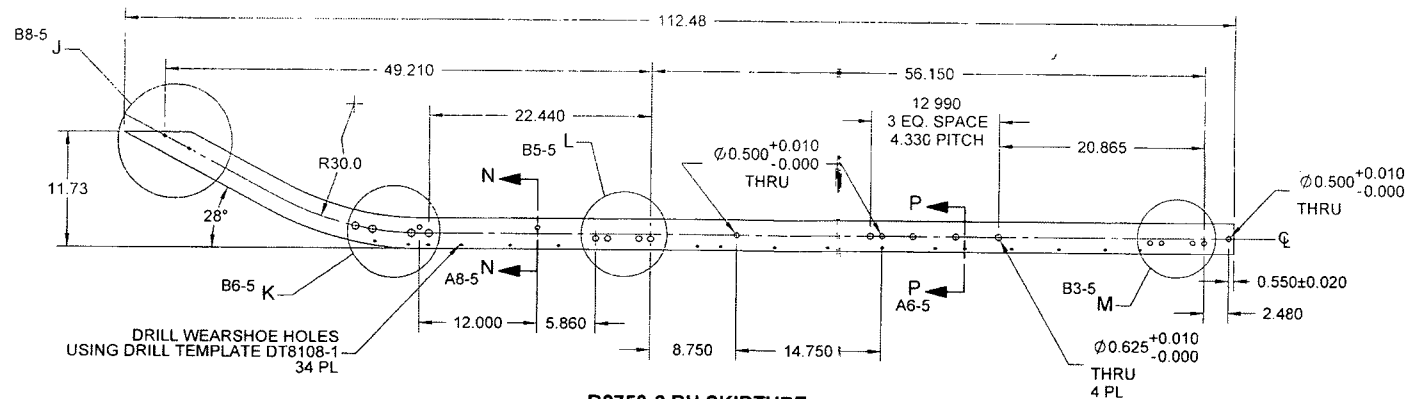
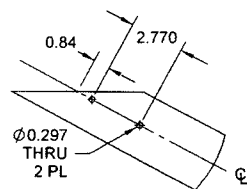
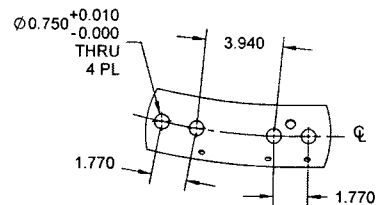
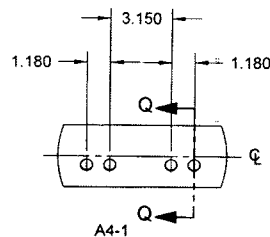
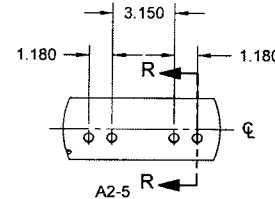
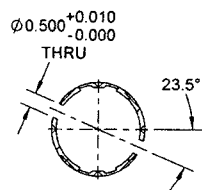
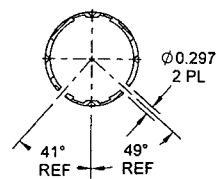
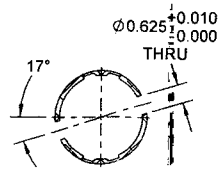
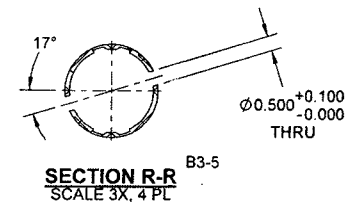


**SECTION H-H**  
SCALE 3X, 4 PL

**RELEASED**

DESIGN	IPB	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	IPB	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		<b>D2750</b>	SHEET 4 OF 11
APPROVED		TITLE	SCALE
DE APPR.		<b>350 SKIDTUBE ASSEMBLY</b>	NTS
DATE	<b>08.07.16</b>	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

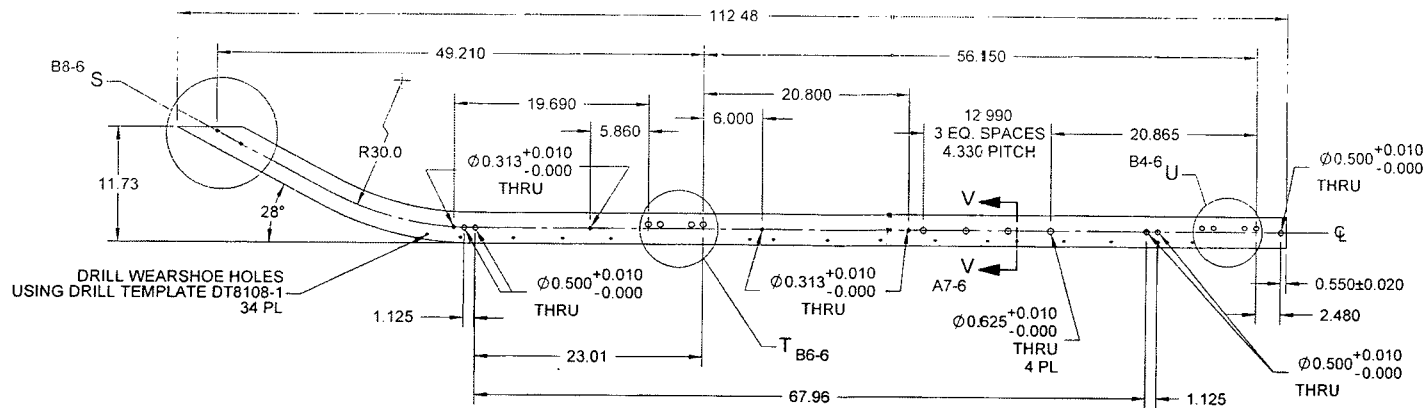
10188(

**D2750-2 RH SKIDTUBE****DETAIL J**  
D8-5  
SCALE 2X**DETAIL K**  
C7-5  
SCALE 2X**DETAIL L**  
D6-5  
SCALE 2X**DETAIL M**  
C3-5  
SCALE 2X**SECTION N-N**  
C6-5  
SCALE 3X, 2 PL**SECTION P-P**  
C4-5  
SCALE 3X, 17 PL**SECTION Q-Q**  
B5-5  
SCALE 3X, 4 PL**SECTION R-R**  
B3-5  
SCALE 3X, 4 PL**RELEASED**

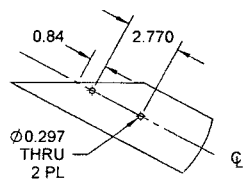
DESIGN		<b>DART AEROSPACE USA, INC.</b>	
DRAWN	<i>PK</i>	PORT HADLOCK, WA	
CHECKED	<i>PK</i>	DRAWING NO. <b>D2750</b>	REV. F
MFG. APPR.	<i>PK</i>	TITLE <b>350 SKIDTUBE ASSEMBLY</b>	SHEET 5 OF 11
APPROVED	<i>PK</i>	SCALE	NTS
DE APPR.	<i>PK</i>		
DATE	08.07.16		

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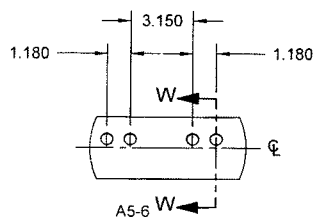
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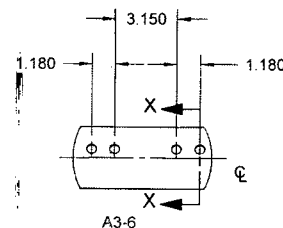
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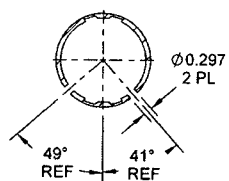
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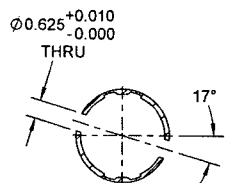
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SCALE 2X



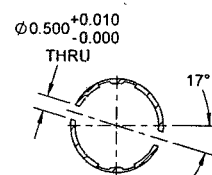
**DETAIL U**  
SCALE 2X



**SECTION V-V**  
SCALE 3X, 17 PL









**SECTION W-W**  
SCALE 3X, 4 PL



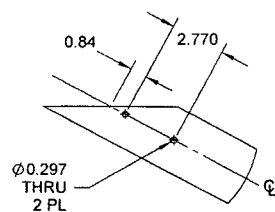
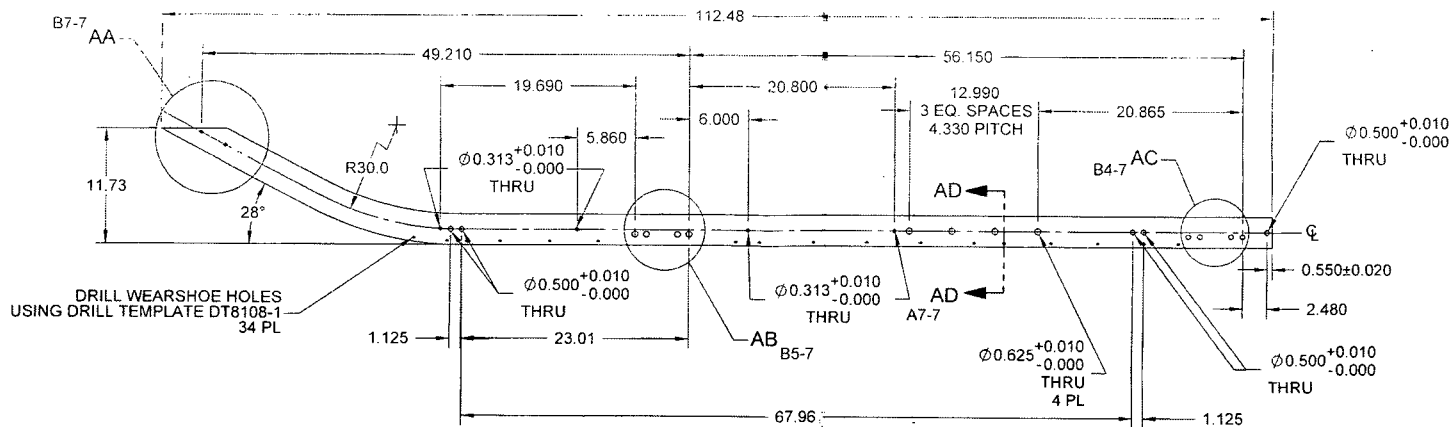
**SECTION X-X**  
SCALE 3X, 4 PL

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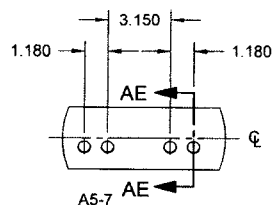
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CHECKED		DRAWING NO.	REV. F
MFG. APPR.		<b>D2750</b>	SHEET 6 OF 11
APPROVED		TITLE	SCALE
DE APPR.		<b>350 SKIDTUBE ASSEMBLY</b>	NTS
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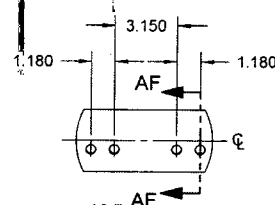
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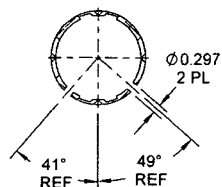
**DETAIL AA**  
SCALE 2X  
D7-7



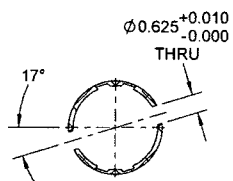
**DETAIL AB**  
SCALE 2X  
C4-7



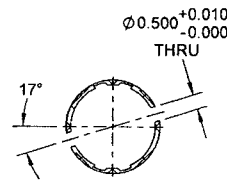
**DETAIL AC**  
SCALE 2X  
D3-7



**SECTION AD-AD**  
SCALE 3X, 17 PL  
D3-7









**SECTION AE-AE**  
SCALE 3X, 4 PL  
B6-7

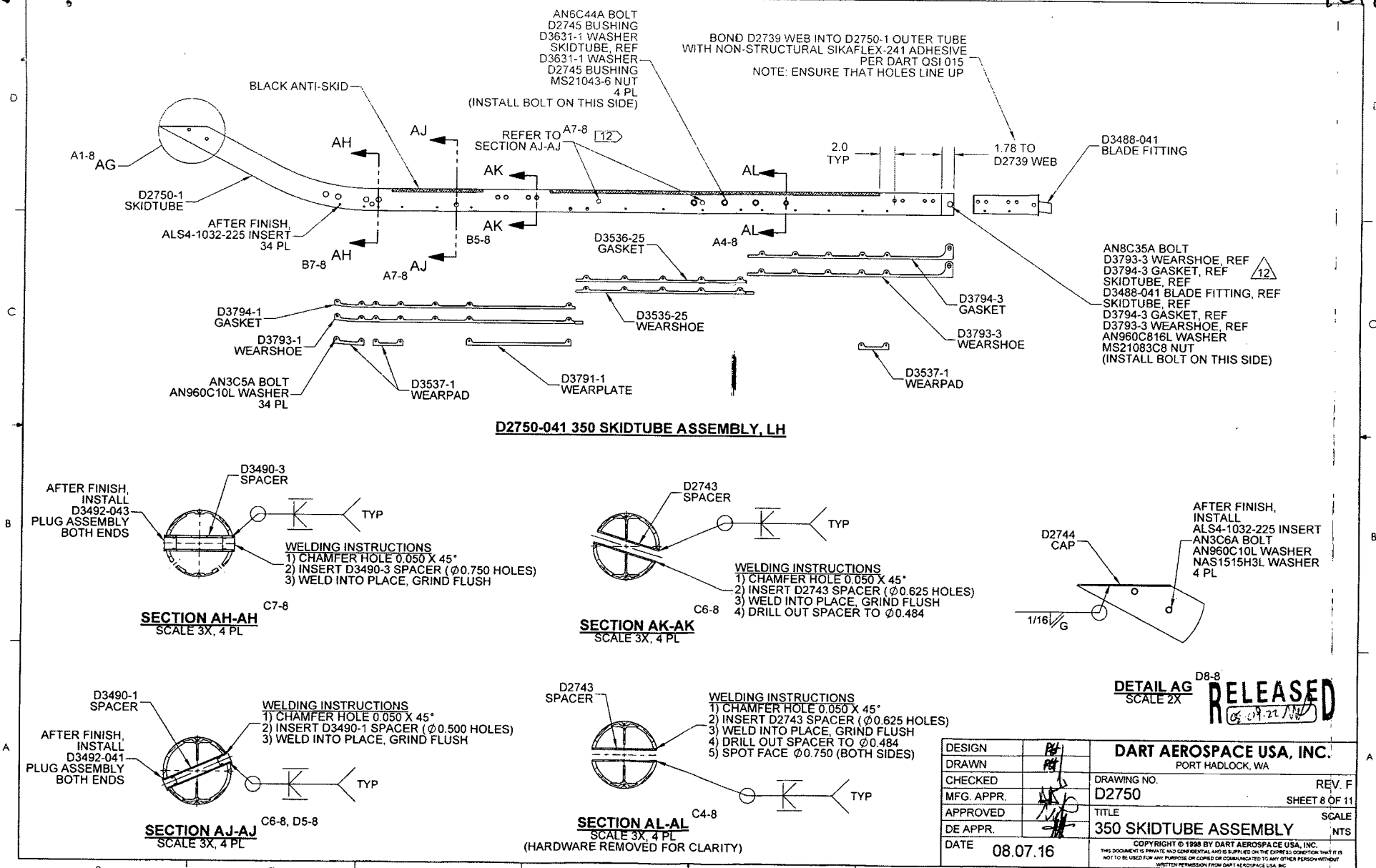


**SECTION AF-AF**  
SCALE 3X, 4 PL  
B4-7

**RELEASED**  
08-09-22-16

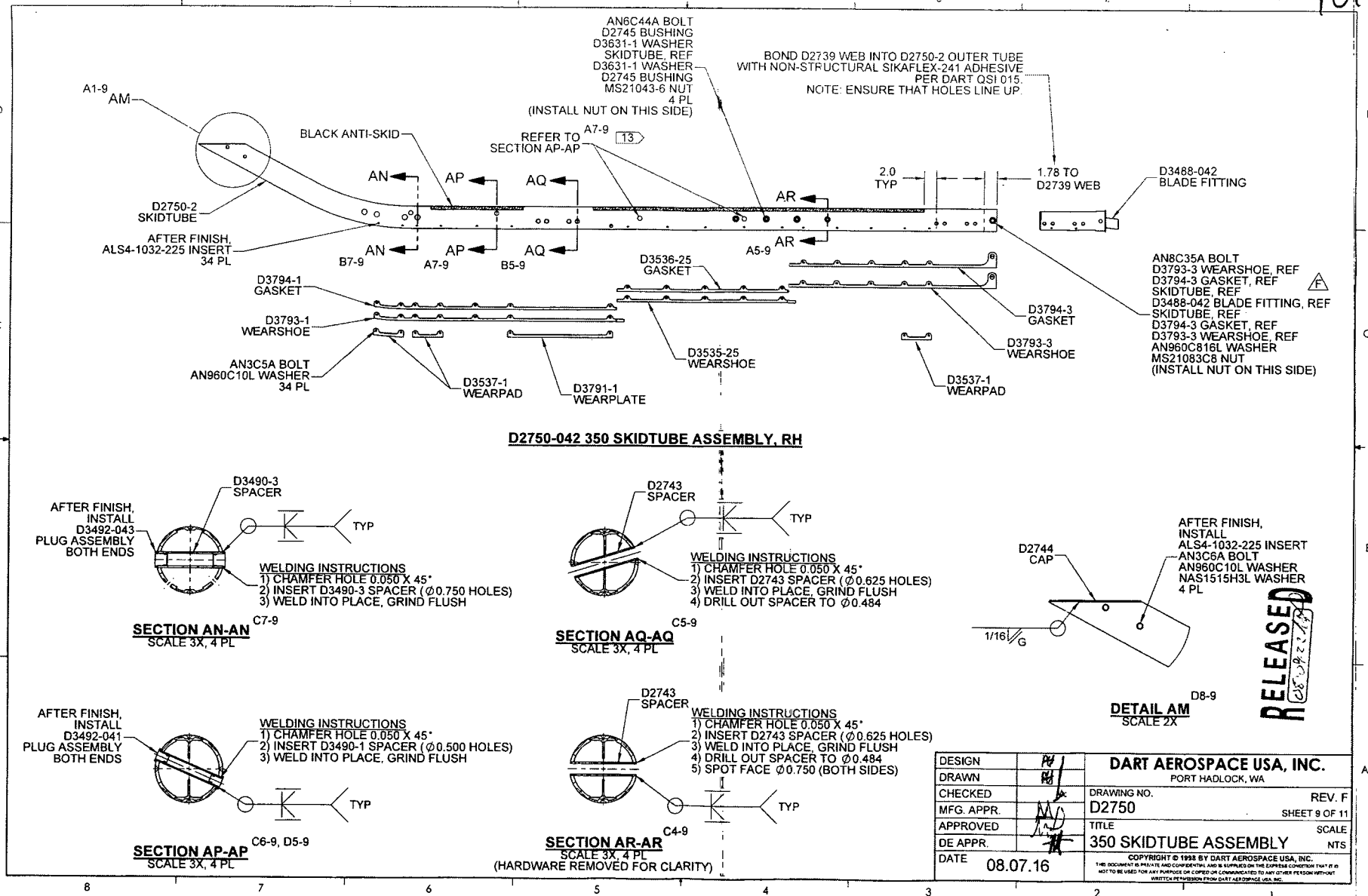
DESIGN		<b>DART AEROSPACE USA, INC.</b>	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 7 OF 11
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101221

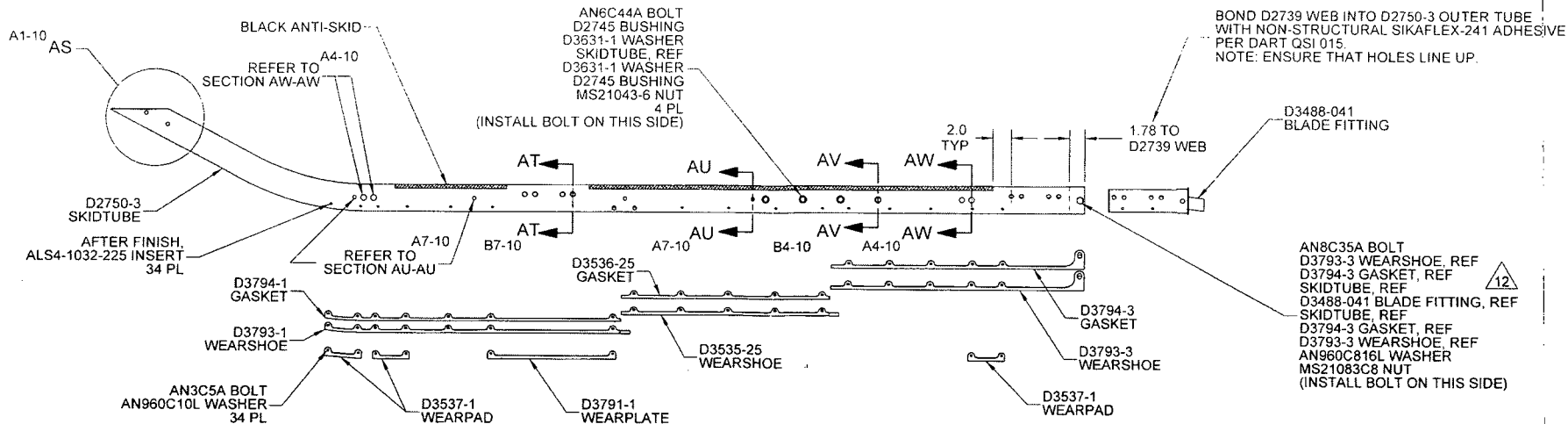


DESIGN	PA	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	PA	PORT HADLOCK, WA	
CHECKED	PA	DRAWING NO.	REV. F
MFG. APPR.	PA	<b>D2750</b>	SHEET 8 OF 11
APPROVED	PA	TITLE	SCALE
DE APPR.	PA	<b>350 SKIDTUBE ASSEMBLY</b>	NTS
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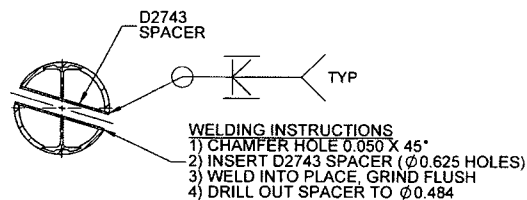
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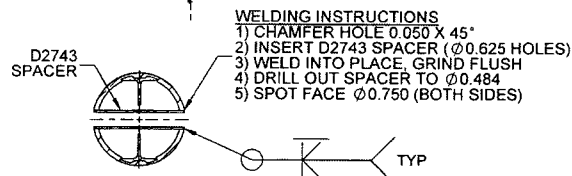
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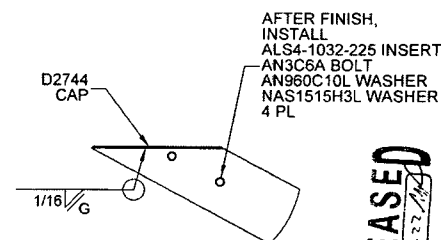
**D2750-043 350 SKIDTUBE ASSEMBLY, LH**



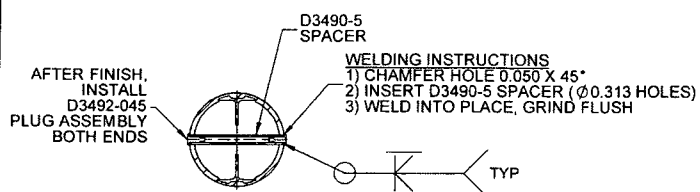
**SECTION AT-AT**  
SCALE 3X, 4 PL



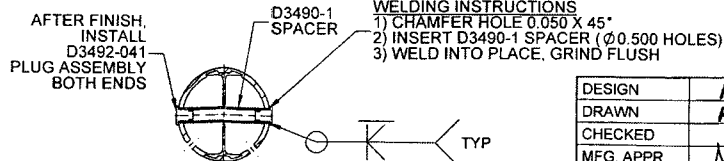
**SECTION AV-AV**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)



**DETAIL AS**  
SCALE 2X



**SECTION AU-AU**  
SCALE 3X, 4 PL

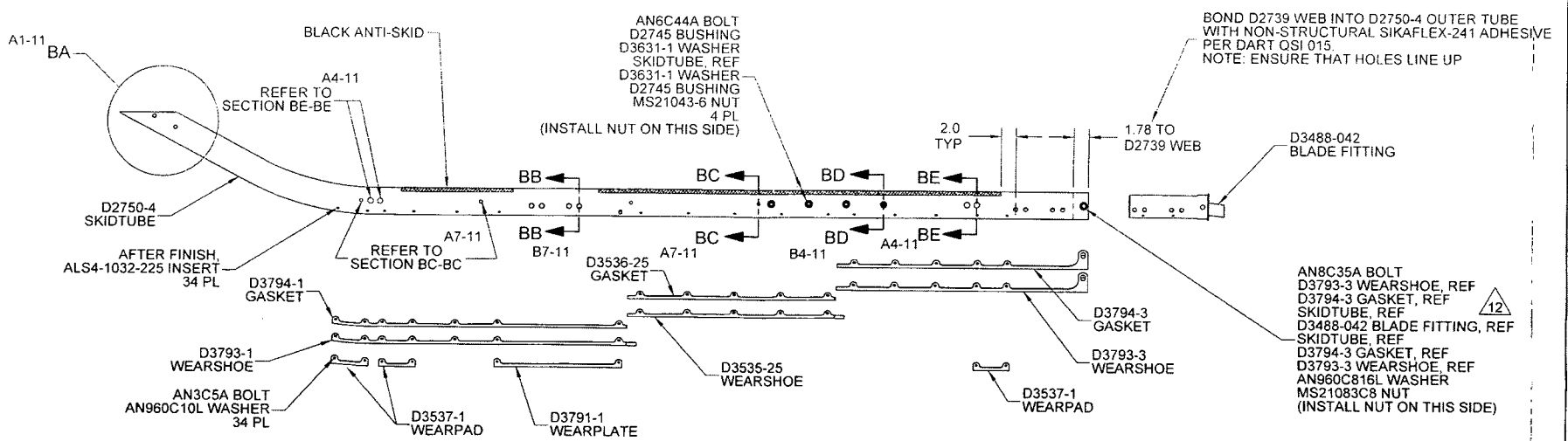


**SECTION AW-AW**  
SCALE 3X, 4 PL

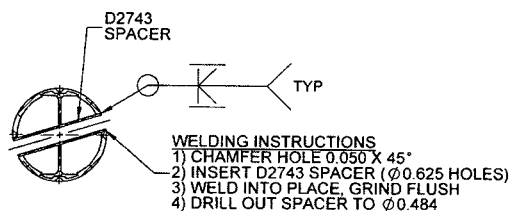
DESIGN	RE	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RE	PORT HADLOCK, WA	
CHECKED	RE	DRAWING NO.	REV. F
MFG. APPR.	RE	D2750	SHEET 10 OF 11
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27 JUL 2001

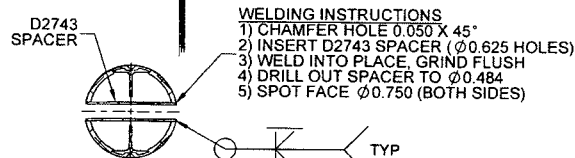
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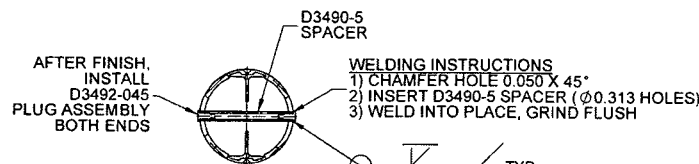
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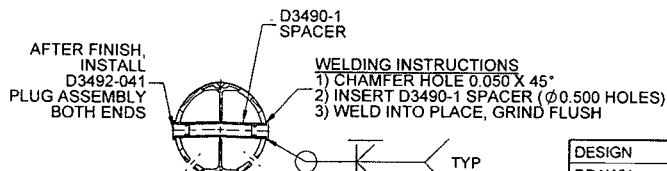
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D6-11  
SCALE 3X, 4 PL



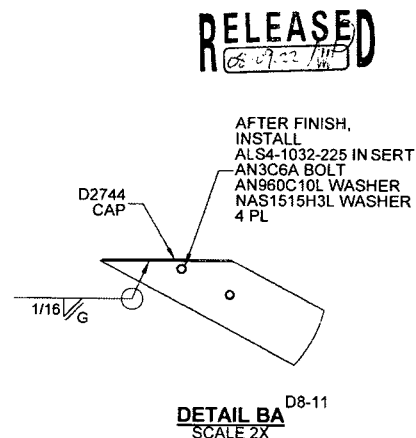
**SECTION BD-BD**  
D4-11  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)



**SECTION BC-BC**  
D5-11, C6-11  
SCALE 3X, 4 PL



**SECTION BE-BE**  
D4-11, D7-11  
SCALE 3X, 4 PL



**RELEASED**

DESIGN	ME	<b>DART AEROSPACE USA, INC.</b>	
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MFG. APPR.	ME	D2750	SHEET 11 OF 11
APPROVED	ME	TITLE	SCALE
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NO. 321

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job #: 99912  
Part #: D350-626-213  
Description: 350 x 10 tube  
Welding Process: Tig ☒ Mig ☐  
Base material: Aluminum  
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual:	pass	<input checked="" type="checkbox"/>	fail	<input type="checkbox"/>
Incomplete Penetration:	pass	<input checked="" type="checkbox"/>	fail	<input type="checkbox"/>
Incomplete Fusion:	pass	<input checked="" type="checkbox"/>	fail	<input type="checkbox"/>
Cracks:	pass	<input checked="" type="checkbox"/>	fail	<input type="checkbox"/>
Overlap (cold lap)	pass	<input checked="" type="checkbox"/>	fail	<input type="checkbox"/>
Undercut:	pass	<input checked="" type="checkbox"/>	fail	<input type="checkbox"/>
Pin holes:	pass	<input checked="" type="checkbox"/>	fail	<input type="checkbox"/>
Porosity (surface):	pass	<input checked="" type="checkbox"/>	fail	<input type="checkbox"/>
Coloration:	pass	<input checked="" type="checkbox"/>	fail	<input type="checkbox"/>
Burn through:	pass	<input checked="" type="checkbox"/>	fail	<input type="checkbox"/>

Qualifier (DAS) 09 Date of Test Coupon 13-05-14  
Welder Barclay Elliott Date of Test Coupon 13-05-14

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Work Order ID 101881

5/17/13 1:52:53 PM

\*101881\*

ID: D350-636-014

Revision ID:

Name: Skidtube RH

Start Date: 5/17/13 Start Qty: 1.00

Required Date: 5/31/13 Req'd Qty: 1.00

Reference:

Tools: Process Plan: *MLS*

QC:

Date: *13-05-17* Tooling:

Date: SPC (Y/N):

Process ID/ Center ID	Operation Description
W Nbr	Revision Nbr

50

F

92

C

10\*

DOCUMENT CONTROL

Document Control

Memo *ML*

Photocopy blue file and type labels per PPP D350-636-014 CHG 006

Accept

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Run Start \*NR1\*

Stop \*NR2\*

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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*MLS 13-06-12*